

Solid and Cored Wires



- EN 29453 compliant alloys
- A flux for every application
- Sizes from Ø 0.3 mm
- Extensive Lead-Free range
- High temperature solutions

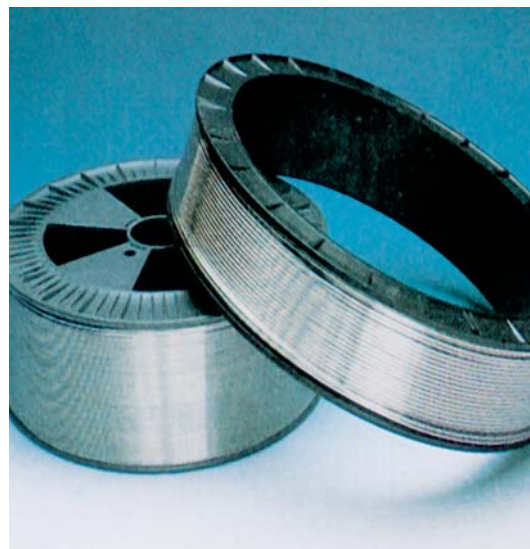
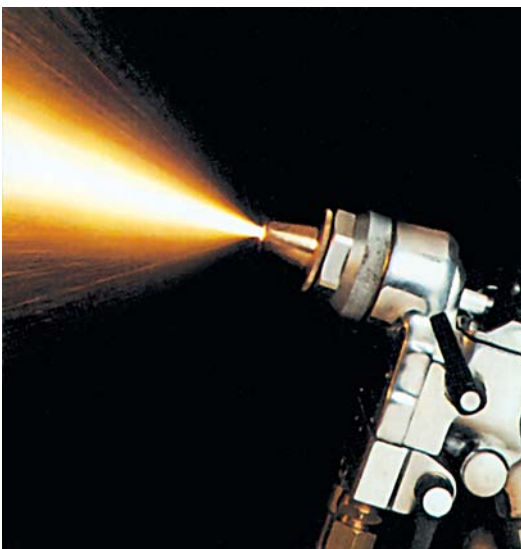
The four characteristics that define a soldering wire are the alloy, the diameter, the type of flux and the winding. Of the many thousand possible permutations, Métaconcept has selected an extensive but consistent range of products suitable for all the main types of application. These products are based on the following major standards:

AVAILABLE ALLOYS

EN 29453 classification	Melting point		EN 29453 classification	Melting point	
	Solid	Liquid		Solid	Liquid
1 - Sn63Pb37	183° C		22 - Sn50Pb32Cd18	145° C	
2 - Sn60Pb40	183° C	190° C	23 - Sn99Cu1 (lead free)	230° C	240° C
3 - Pb50Sn50	183° C	215° C	24 - Sn97Cu3 (lead free)	230° C	250° C
5 - Pb60Sn40	183° C	235° C	28 - Sn96Ag4 (lead free)	221° C	
7 - Pb70Sn30	183° C	255° C	34 - Pb93Sn5Ag2	296° C	301° C

FLUX

Type	Nature	J-STD-004 classification	Acid index (mg KOH/g)	Halogen content (wt %)
RS7MI	Resin	ROM 1	175 - 195	1.45 - 1.80
Fluitin 1532	Resin	ROM 1	170 - 190	0.80 - 1.10
Fluitin 1535	Resin	ROL 1	170 - 190	0.35 - 0.45
AS2	Resin	ROL 0	185 - 200	-
HK2	Organic	ORH 1	-	0.95 - 1.05



STANDARD DIAMETERS AND REEL SIZES

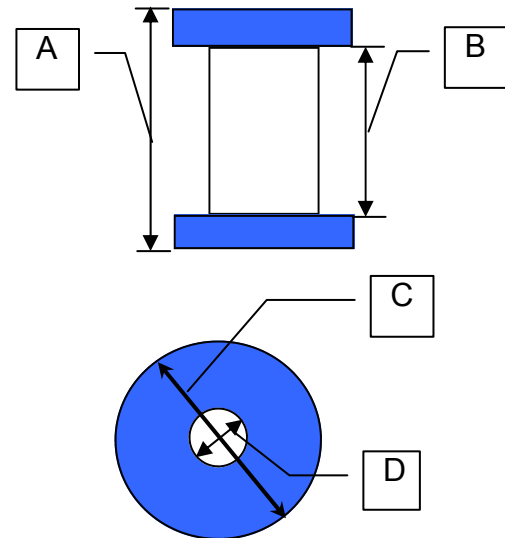
Standard dies can produce wire in diameters from 0.3 mm up to 6 mm. The main gauges between these two extremes are 0.4, 0.5, 0.7, 0.8, 1.0, 1.25, 1.40, 1.50, 2.0, 2.5, 3.0, 4.0 and 5.0 mm.

Common reel sizes are 100g, 250g, 500g, 1Kg, 2.5Kg, 5Kg, 10Kg, 12Kg and 20Kg. For high-volume industrial applications, 20 Kg and 100Kg drums are also available.

REEL AND PACKAGING TYPES

The type of reel used varies according to the required capacity. For industrial use, reels larger than 250g are of the DIN type. The following tables can be used to identify a reel and its dimensions according to the net weight of wire stored on it and the standard package weight.

Size	Type	Unit of sale
100g	PER49	5Kg
250g	DIN63	5Kg
500g	DIN63	10Kg
1Kg	DIN80	20Kg
2.5Kg	DIN100	20Kg
5Kg	DIN125	20Kg
10Kg	DIN159	20Kg
12Kg	DIN369	12Kg
20Kg	DIN299	20Kg
20Kg Pops	Pops20	20Kg
100 Kg Pops	Pops100	100Kg



Type	A (mm)	B (mm)	C (mm)	D (mm)
PER49	37	34	49	15
DIN63	63	49	63	11.5
DIN80	80	64	80	16
DIN100	100	80	100	16
DIN125	125	100	125	16
DIN159	150	127	150	21
DIN369	80	70	369	306
DIN299	100	91	299	51
20Kg Pops	Height 256		310	160
100 Kg Pops	Height 520		490	360

TYPICAL APPLICATIONS

Electricity
 Plumbing - Sanitation - Heating
 Electromechanical engineering
 Tinsplate work

INSTRUCTIONS FOR USE

Do not inhale flux fumes during brazing. Ensure that the workstation is well-ventilated. We recommend installing a fume extraction system at each workstation. Feel free to contact us for advice on this subject.

NOTES

In most applications, the assembled workpieces may contain residual traces of flux. To obtain a perfect finish (and prevent any risk of short-circuits in electrical applications), we recommend cleaning workpieces with a foaming agent.

Refer to our "**Chemical products**" information sheet to find the most suitable product for your application .